

Date:
User:Wednesday, 29/10/2008 7:59:58 AM
Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 43053

Estimate Number : 13529

P.O. Number :

This Issue : 29/10/2008

Prsht Rev. : NC

First Issue : 1/1

Previous Run : 41384

Written By :

Checked & Approved By :

Comment :

Drawing Name : SHORT T-HANDLE ASSY

Part Number : PB674300163

Drawing Number : B6743001 P.15

Project Number : N/A

Drawing Revision : B1

Material :

Due Date : 05/11/2008

Qty:

Um: Each

Est Rev:A 08-07-29 new issue DD verified by:ec

split

mf 08-11

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PB6743001131

Tube End Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Tube End Cap

batch: 41480

2.0

PB6743001129

Tube Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Tube Handle

batch: 40019

3.0

PB6743001127

Handle Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Arm

batch: 41479 B40018, B43327

4.0

PB6743001157

Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Tube

batch: 40026

5.0

CR321342

Cherry Rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivet

batch: M102569

mf 08-11-11

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT T-HANDLE ASSY

Job Number: 43053

Part Number: PB674300163

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- chamfer both ends (0.090") on -129 and -127
- 2- chamfer (0.090") only the angle end on -157
- 3- drill #40 hole in center of -129 before welding -131 caps, to let air out
- 4- weld -131 to -129 as per dwg
- 5- grind weld flush
- 6- assemble -127 under the pilot hole in -129 and -157 weld as per dwg
- 7- grind weld flush
- 8- install rivet as per dwg

M110130

EL 8-12-11

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

CP 08.12.12 BE (K)

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/12 (K)

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

M 10 2316

(K)

****mask only -157 starting from rivet to end of -157 tube, rivet must be powder coat****
Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1-30
320 °F
2-00

M 08/12/12

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F 08/12/15 (1)

11.0 240107 SPRING SLOTTED PIN

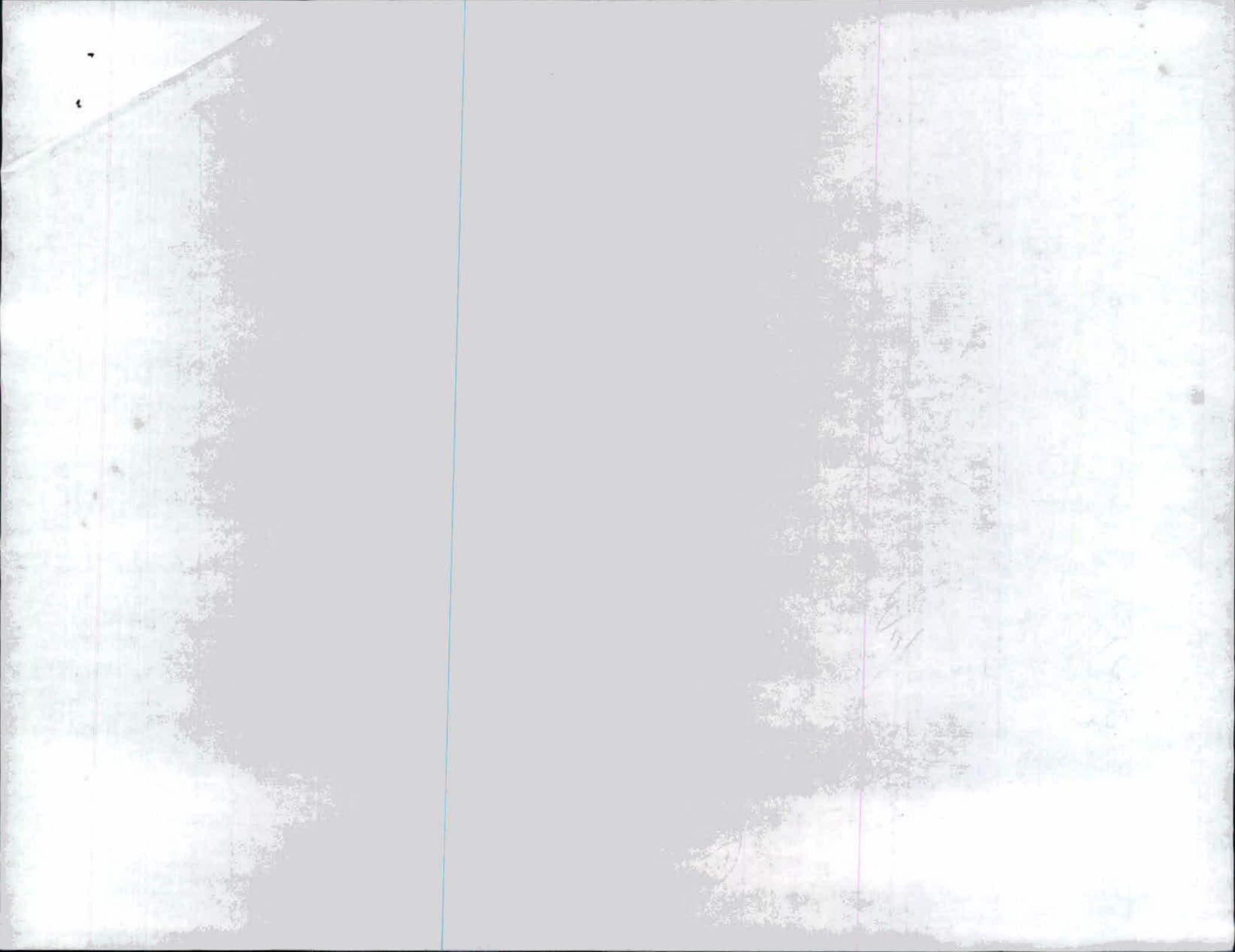


Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

SPRING SLOTTED PIN

batch: M17850

CP 08.12.12 (1)



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT T-HANDLE ASSY

Job Number: 43053

Job Number:

Part Number: PB674300163

Seq. #:

Machine Or Operation:

Description:

12.0

PB6743001133

Clevis

Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Clevis
batch: 023994 ✓

13.0

PB6743001137

Locking Sleeve

Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Locking Sleeve
batch: 023996 ✓

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble by drilling thru both -157 and -133 as per dwg
2- install spring slotted pin as per dwg

15.0

QC5

INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

16.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 440

17.0

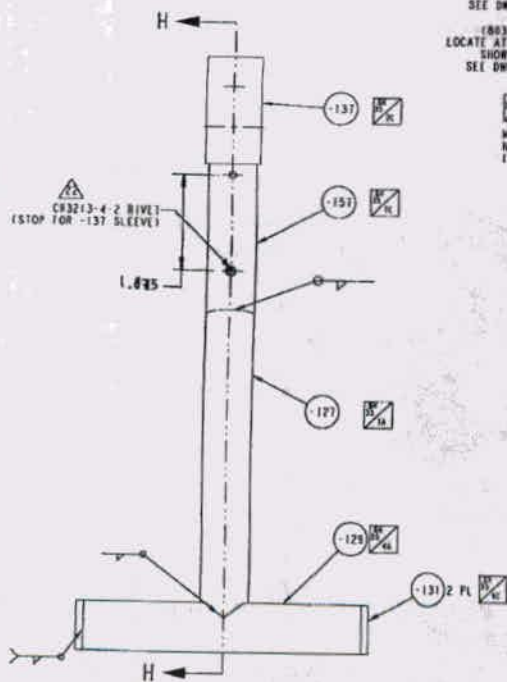
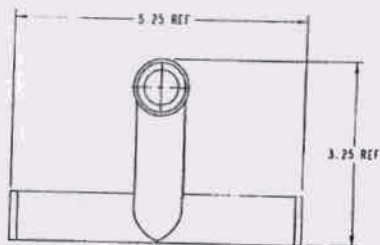
QC21

FINAL INSPECTION/W/O RELEASE

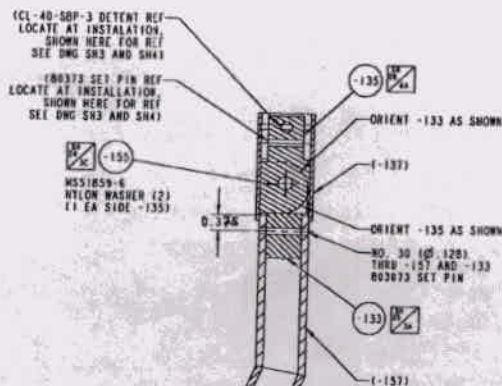
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



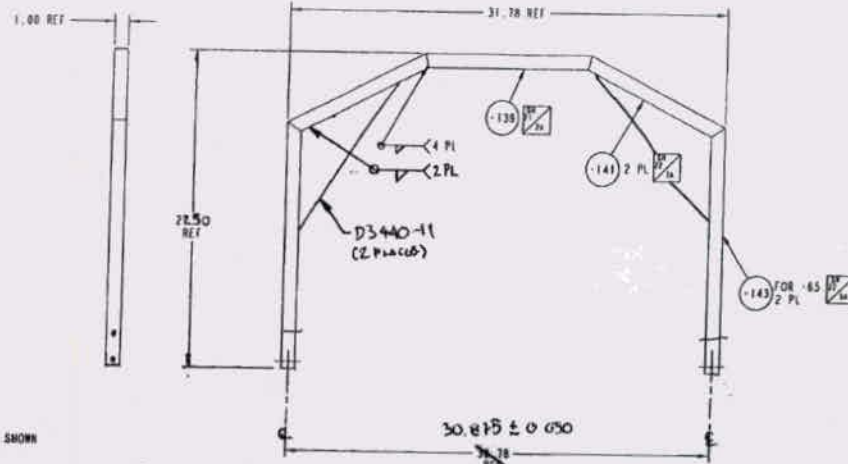


① -63 SHORT T-HANDLE ASSEMBLY
SCALE 1.000



SECTION H-H

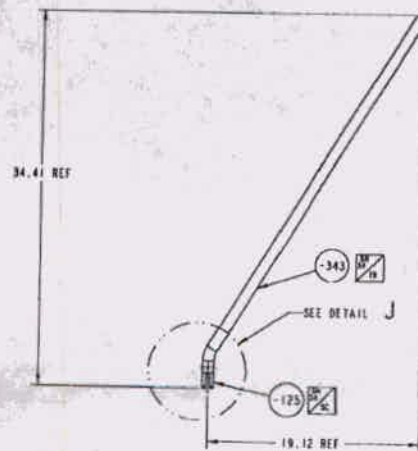
#43053



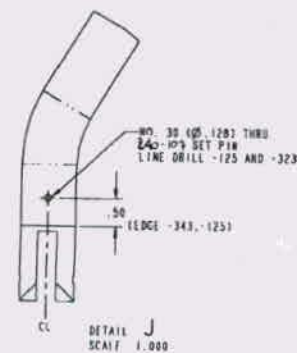
RELEASED

① -63 BASE ASSEMBLY (COMMERCIAL VERSION)
SCALE 0.250

-47 BASE ASSEMBLY (CANADIAN VERSION)
(CANADIAN VERSION)



① -37 TUBE ARM ASSEMBLY
SCALE 0.700



PREMIER AVIATION, INC.
3000 Aviation Parkway, Grand Prairie, Texas 75050
REV. 0105UV8 B67-43001
DATE: 01/81 BY: 15 OF 45

ORIGINAL

